

Date: Monday, 28/05/2007 9:08:16 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET LOCATOR
Job Number : 31923	
Estimate Number : 11230	
P.O. Number : <i>N/A</i>	Part Number : D23693
This Issue : 28/05/2007 S.O. No. : <i>NA</i>	Drawing Number : D2369 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31923	Material : <i>NA</i>
Written By : <i>[Signature]</i>	Due Date : 05/06/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev A Removed from 9 Digit 05-12-05 JLM Est Rev:B Now on Waterjet 07-05-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 1.4217 sf(s)/Unit Total: 14.2170 sf(s)
 Material: 5052-H34 or H32 0.040" thick
 (M5052H32S.040)
 Batch: *414050*

SAD 07/05/31

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

SAD 07/05/31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/31

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SAD 08/01/07 (+10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1
Debur

SAD 08/01/07 (+10)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SAD 08/01/07 (+10)

Date: Monday, 28/05/2007 9:08:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 31923

Part Number: D23693

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 178

8/1/1

SP

(10x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

18
D 08/01/08

Job Completion



2007/1/7

W

PTD

Date: Tuesday, 4/17/2007 3:56:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET LOCATOR
Job Number	: 31923		
Estimate Number	: 11230		
P.O. Number	:	Part Number	: D23693
This Issue	: 4/17/2007 S.O. No. :	Drawing Number	: D2369 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 5/2/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>4/20/07.18</u>		
Comment	: Est Rev A Removed from 9 Digit 05-12-05 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
-----	--------------	---------------------



Comment: Qty.: 1.4217 sf(s)/Unit Total : 14.2170 sf(s)
 Material: 5052-H34 or H32.0.040" thick
 (M5052H32S.040)
 Batch: _____

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut blanks: 39.0" x 5.00

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D2369-3 as per Folio D2369-3 and Dwg D2369

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

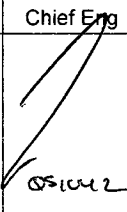
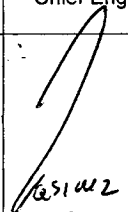
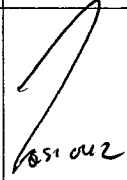
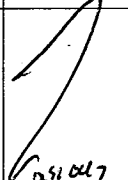



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/31	2.0	hole's on Part were to big had to change the offset E.C. Hammer error		Scrap destroy - replace Qty 1 part	SAD 07/07/71	Si 07/06/18		Si 07/06/18
07/05/31	2.0	wrong mat. was used 0.050" thick instad of 0.040" mat.		Parts are Parts are acceptable	SAD 08/04/07	Si 08		
		E.C. Hammer error						

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 31923

Part Number: D23693

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

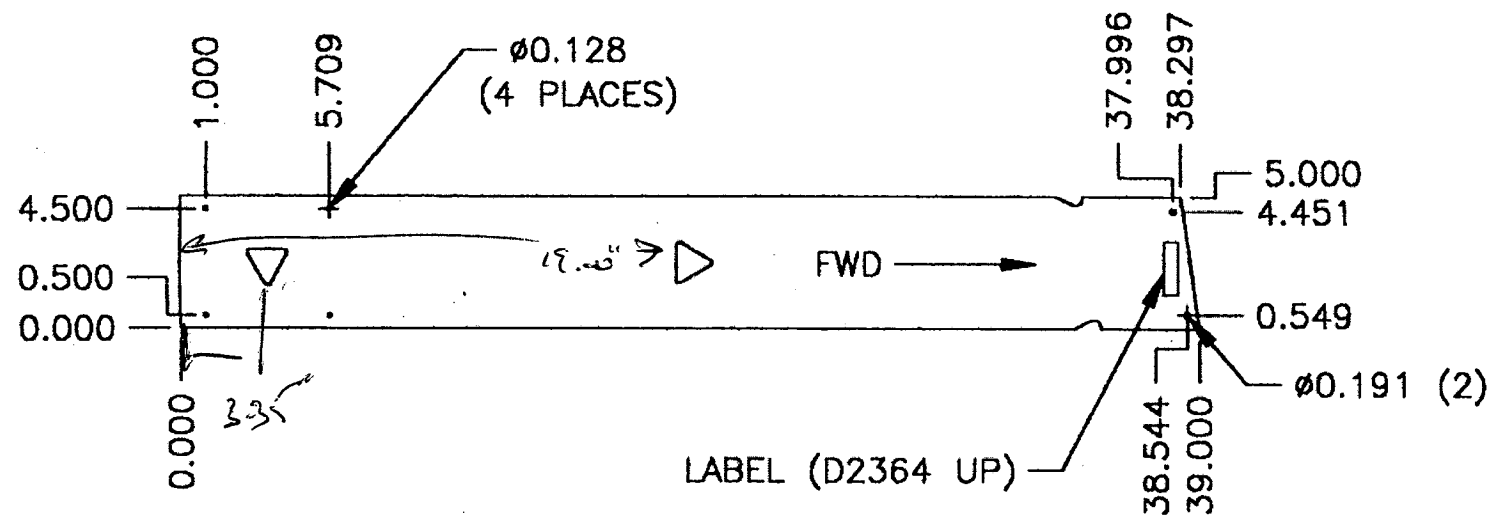
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. A
CHECKED	B WILLIAMS	APPROVED	[Signature]	DRAWING NO. D2369	SHEET 1 OF 2
DATE	95:02:20	TITLE	DECK PLATE LOCATOR BRACKET	SCALE	1:1

RELEASED
960610



D2369-1

MATERIAL: 5052-H34 0.040 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31923



1:7

960610

